

Work Order ID 76642-*split*

76642

Page 1

November 18, 2011 10:24:09 AM

Item ID: D2230-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lug

Start Date: 11/18/11

Start Qty: 200.00

200

Cust Item ID:

Required Date: 11/30/11

Req'd Qty: 200.00

200

Customer:

Reference:

Approvals:

Process Plan: *cd*

Date: *11/18/11*

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.82"

Batch: *B68331*

cut @ meter

cd 11/18/11

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1 *Search.*

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA927

FOLIO REV: _____

DWG REV: _____

Check for crack while loading into the machine.

2- deburr

P/O: 15479

cd 11/18/11

200

issue P/O: to meter

machine as per dwg D2230 REV. G

W/O:		WORK ORDER CHANGES					
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N9000040100

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Revision ID:

Stop ***NS2***

Item Name: Lug

Start Date: 11/18/11 Start Qty: 200.00

200

Cust Item ID:

Required Date: 11/30/11 Req'd Qty: 200.00

200

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120 *rec'd*

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

*rec'd + inspect for transit damage
attached c/c to W/O.*

11/14/30 (200)

130

QC3- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

11. 11. 30 (200)

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

200 X Ø m-f 11/11/30

W/O:		WORK ORDER CHANGES					
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200

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200

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

198. 11-12-7.

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

170

Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:00

OVEN TEMPERATURE: 320 OF

FINISH TIME: 1:30

198X M-11/12/07

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

198 11-12-7

M119480

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N900040100

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Stop *NS2*

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200

Cust Item ID:

Required Date: 11/30/11 Req'd Qty: 200.00

200

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

190

Identify as per dwg & Stock Location:

0.00

190

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

Full 11/13 (198)

11/12/13

mf 11-12-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

November 18, 2011 10:24:09 AM

Page 1

Work Order ID: 76642
Parent Item: D2230-3
Parent Item Name: Lug

Start Date: 11/18/11
Start Qty: 200.00

Required Date: 11/30/11
Required Qty: 200.00

Comments: IPP D00.05.18 Added inspection level 8, and removed P/O for powder
coatEC
BY:EC
IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P ✓ LUG		Purchased	No				Each	0.0000		200			
D2423 Lug Extrusion		Manufactured	No			100	F	455.0800	0.0683	14.378947			

Location

Loc Qty

Loc Code

MAT006

455.08

43722

161.5

45800

1

68331

292.58

14.39

11/14/30 (200)
C. L. L. 11/18

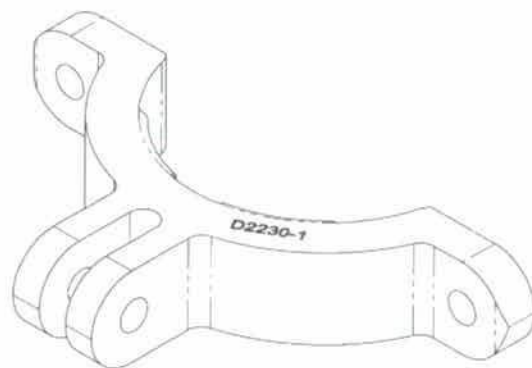
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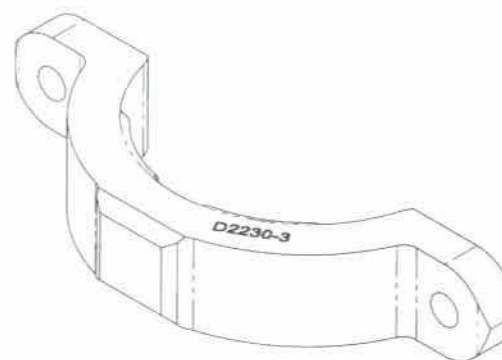
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D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

*c 2/11/18
w10: 76642*

RELEASED
ALB/SM



NOTES

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDESIGNED IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN: R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2230	SHEET: 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR	<i>[Signature]</i>	MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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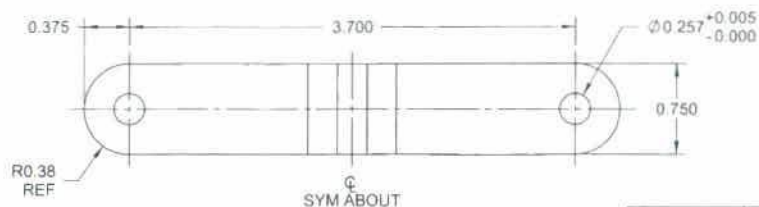
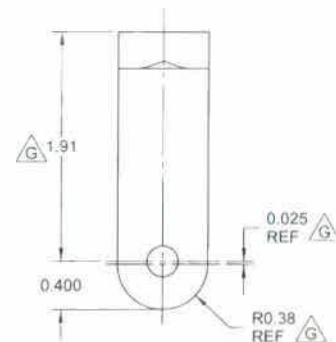
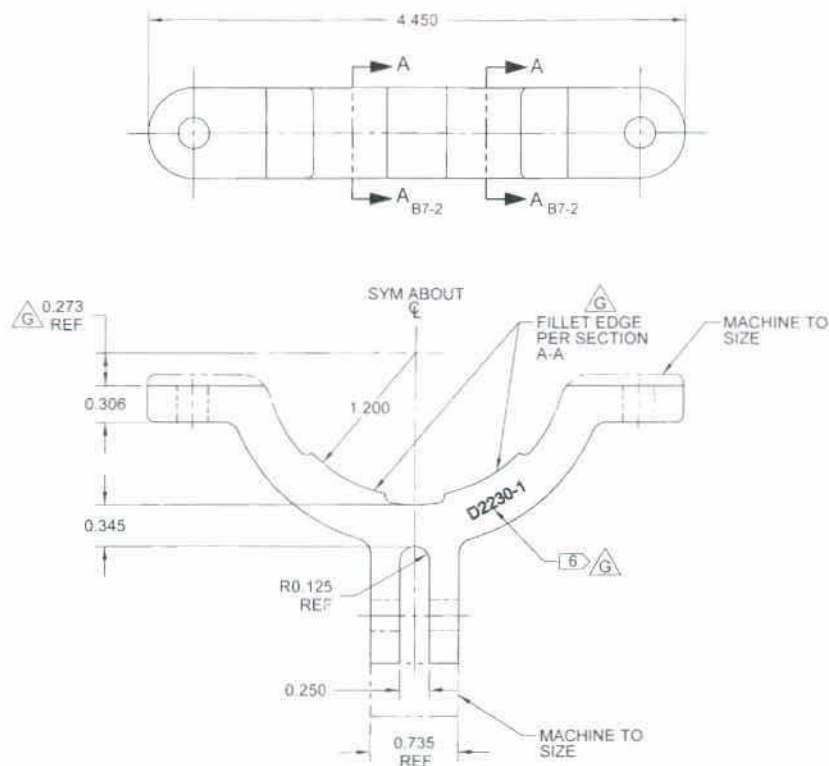
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SECTION A-A D4.2
SCALE 2X

R0.06 MIN - R0.10 MAX
2 PL



D2230-1 MOUNTING LUG

RELEASED
09/06/75

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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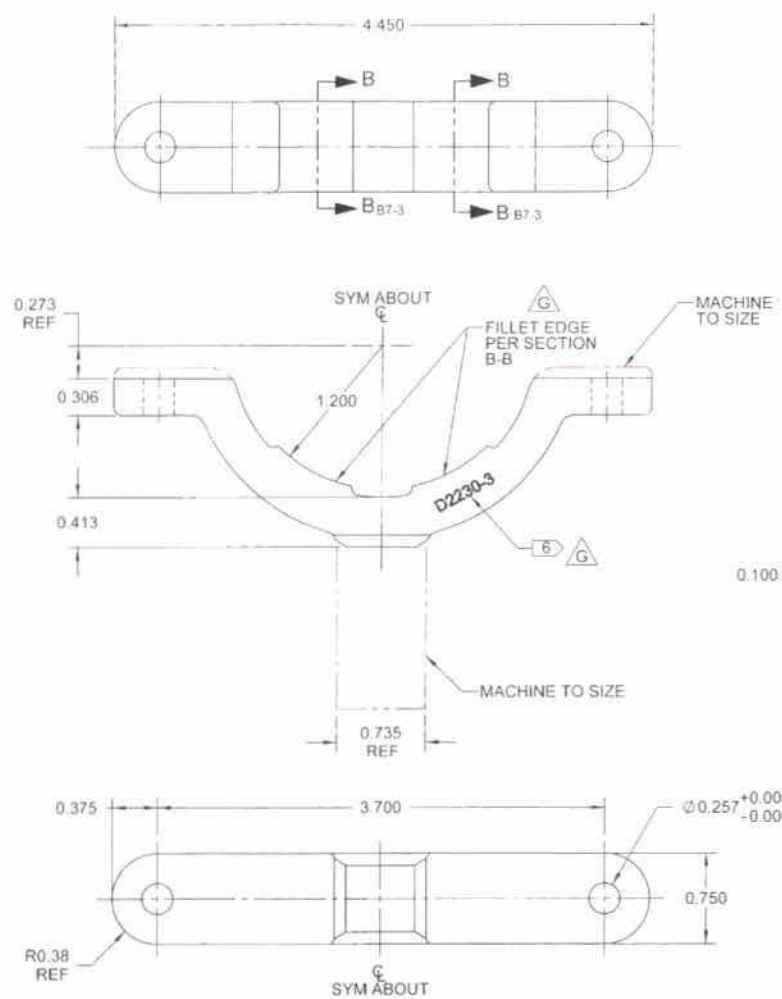
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SECTION B-B
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
01/06/2014

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO	REV G
MFG APPR		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE BASIS OF THE INFORMATION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT DART AEROSPACE LTD'S PERMISSION	

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15479

Purchase Order Date 11/18/11

PO Print Date 11/18/11

Page Number 1 of 1

VC-MET003

TECHNOLOGY INC.
DRIVE PO BOX 781
L. QC K0B 1R0

613 678 3957
613 678 3956

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

DAEROSPACE LTD. 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
	LUG	11/21/11 Yes	200.00 Each	Dart Truck	\$18.9500	\$3,790.00
	Special Inst:	MACHINE AS PER DWG D2230 REV. G B76640				
	LUG	11/18/11 Yes	200.00 Each	Dart Truck	\$13.6000	\$2,720.00
	Special Inst:	MACHINE AS PER DWG D2230 REV. G B76642				

PO Total: \$6,510.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Date: 11/18/11



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18290

Date: Nov 30, 2011

Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO15479	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date: Nov 30, 2011

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug, machine as per drawing D2230 REV.G B76640	Each	200		
D2230-3 Mounting Lug, machine as per drawing DWG D2230 REV.G B76642	Each	200	200	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

200

D2230-3P

Lug

15479

MATERIAL: supplied by DART D3041 B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Jan Norris", is written over a horizontal line.

Jan Norris

Vankleek Hill, November 30 2011